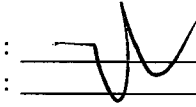


Date: Thursday, 17/01/2008 9:11:38 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MID TUBE ASSEMBLY
Job Number :	36806		
Estimate Number :	11446		
P.O. Number :		Part Number :	D3391013
This Issue :	17/01/2008	Drawing Number :	D3391 REV G
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	G
Previous Run :	32592	Material :	
Written By :		Due Date :	31/01/2008
Checked & Approved By :		Qty:	1
Comment :	Type : LANDING GEAR Um: Each Est. A 05.12.13 New Issue EC Est. B 06.02.09 Dwg rev.D EC Est Rev:06-03-28 Update Manufacturing Instructions JLM est rev D 07.03.14 dwg Rev F EC Est Rev:E ECN 1056 07-11-13 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2500-1-100	Extrusion	
---	-------------	-----------	--

B24593

DP 8-1-17

2.0	D3391011	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: B33632

DP

8-1-17

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes including "B" holes using DT8796 as per Dwg D3391

3-Open float bag holes as per Dwg D3391

4-C'sink float bag holes as per Dwg D3391

5-Open remaining holes as per dwg D3391

6- Locate electric step holes 41.5000" from fwd end and drill using DT 8393

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/01/2008 9:11:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 36806

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7- Open electric step holes 0.332" per dwg D3391 (section L-L)

8- Open electric step holes 0.250" per dwg D3391 (section M-M)

9- Open electric step holes 0.250" per dwg D3391 (section LL-LL)

10- Remove .030" from Fwd indexing Ridge as per Dwg D3391

11- Remove indexing ridge on Fwd & Aft end of skid tube as per Dwg D3391

12- Deburr

13- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.208" holes with paint marker

14- Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391

15- Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391

16- Open .375" holes to .438"

17- Insert D3391-011 and clip in place with wearplate holes, transfer drill saddle holes as per dwg D3391.

18- C'sink holes for crossbolt spacers. *N/A*

19- Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Touch-up alodine in D3391-011

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION


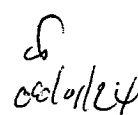
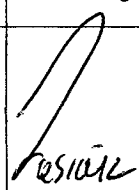





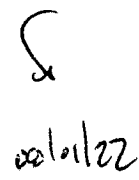


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-013 PAR #: N/A Fault Category: Prod/Landing Gear NCR: Yes No DQA: D Date: 08/01/22
 QA: N/C Closed: _____ Date: _____

NCR: <u>36806</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/22	# 30	the 6 th hole from the Rear end of the D3391-013 (mid tube) is off by 0.500". R.C. the Drill sig sig		Fill in the incorrect hole with weld as per QST004 AIR B2 <u>106390</u>	DE 08/01/22			
		DT 8796 was machined wrong		Grind weld flush. Drill hole in correct location AS per DWG 3391-Rev G, See NCR2 08-013 See PAR08-001 for jig re-work				

NOTE: Date & initial all entries

Date: Thursday, 17/01/2008 9:11:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 36806

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Pick:

Qty Part Number Description Batch

1 D3389-1 Web

A/R

Sikaflex-241/-291

Sikaflex expire date:

Start: 8-1-22 Time: 12:00pm

Finish: 8-1-23 Time: 11:00

B35807
M105469
8-1-30

DP 8-1-22

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

*****Ensure Web Aligment *****

DP 8-1-22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

BE 8-01-23

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Weld crossbolt spacer as per dwg D3391 & QSI 004

CROSSBOLT SPACER D3681-1 B 35814 12Pcs

ALUMINIUM ROB

M106370

BE 08-01-23

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08-01-24

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 08-01-25

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Use paint screws to mask inserts.

M106379

M-1

08/01/25

(IX)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/01/2008 9:11:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 36806

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/01/25 ①

15.0

ALS41032130

Insert



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
INSERT
batch: m105729
or equivalent
per QSI 017

FL

16.0

ALS4428165

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inserts
batch: m6989

FL

17.0

D36721

PHENOLIC WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PHENOLIC WASHER
batch: 834470

FL

18.0

D36723

PHENOLIC WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PHENOLIC WASHER
batch: 834471

FL

19.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
WASHER
batch: m106552

FL

20.0

AN960C416L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
WASHER
batch: m105793

FL 08/01/25 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/01/2008 9:11:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 36806

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS27039C109

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: m17831

FL

22.0

MS27039C408

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: m17831

FL

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Assemble as per dwg D3391

FL 08/01/25 (1)

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/20 (1)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 35921 08/01/29 (1)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/29

Job Completion



u 08-01-29

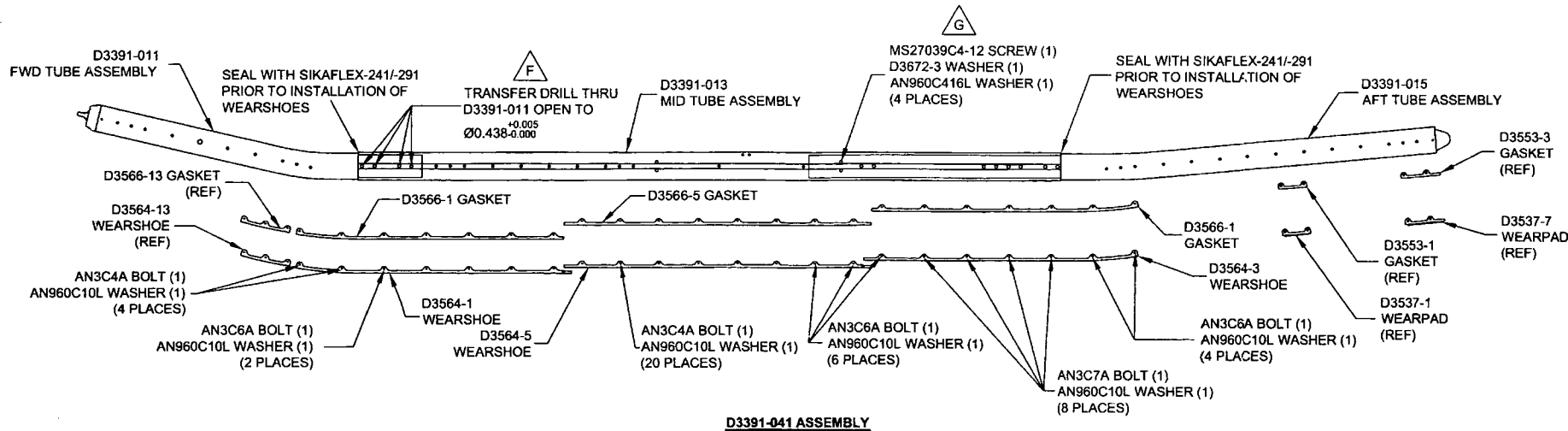
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE REV. G SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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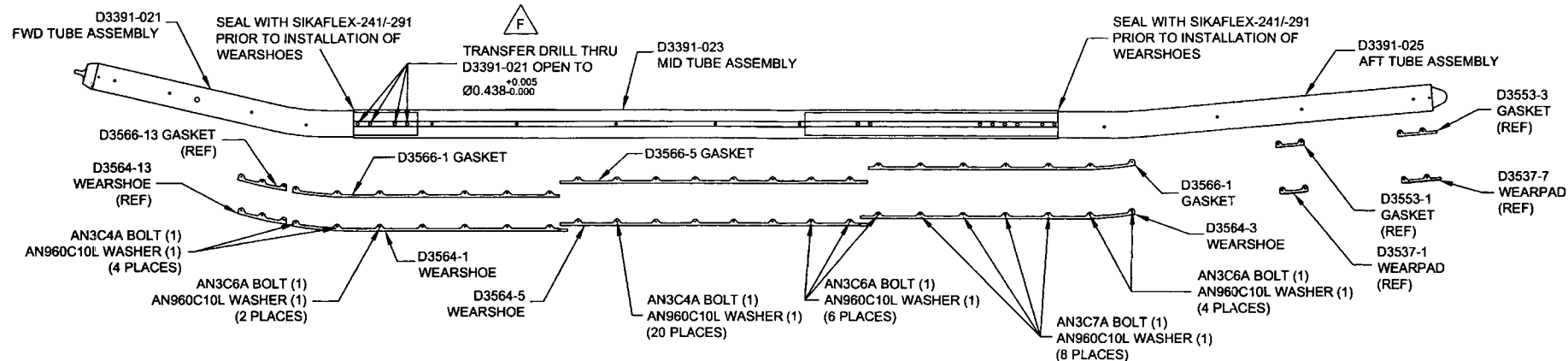
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-043 ASSEMBLY

RELEASED
07.11.94

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JP	D3391	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

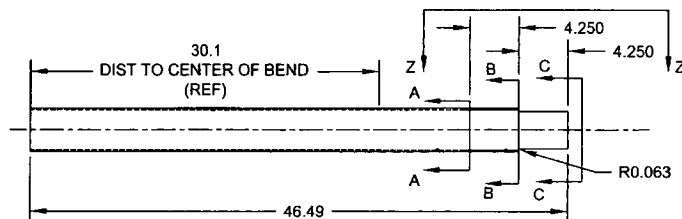
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

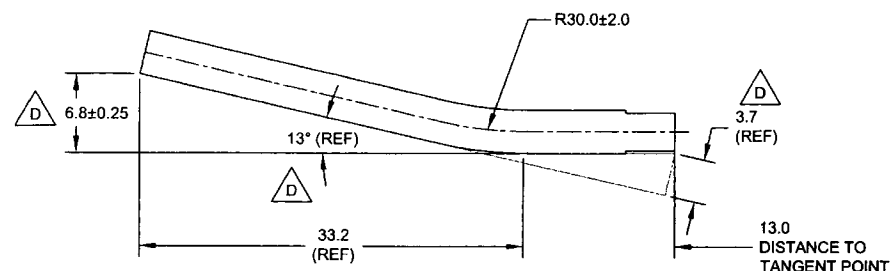
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

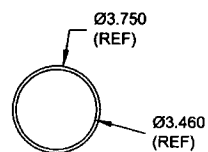
NOTE: Date & initial all entries



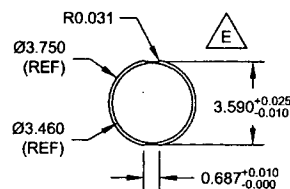
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



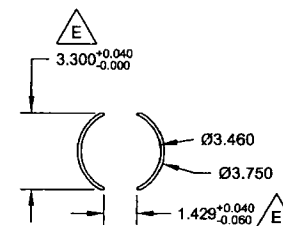
D3391-0111-021 BENDING DETAIL
(MAKE FROM D3391-1)



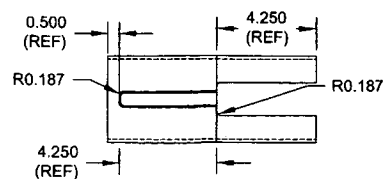
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)

RELEASED
07-11-06

DESIGN		DART AEROSPACE USA, INC
DRAWN	JC	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D3391 SHEET 3 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE 1:10
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

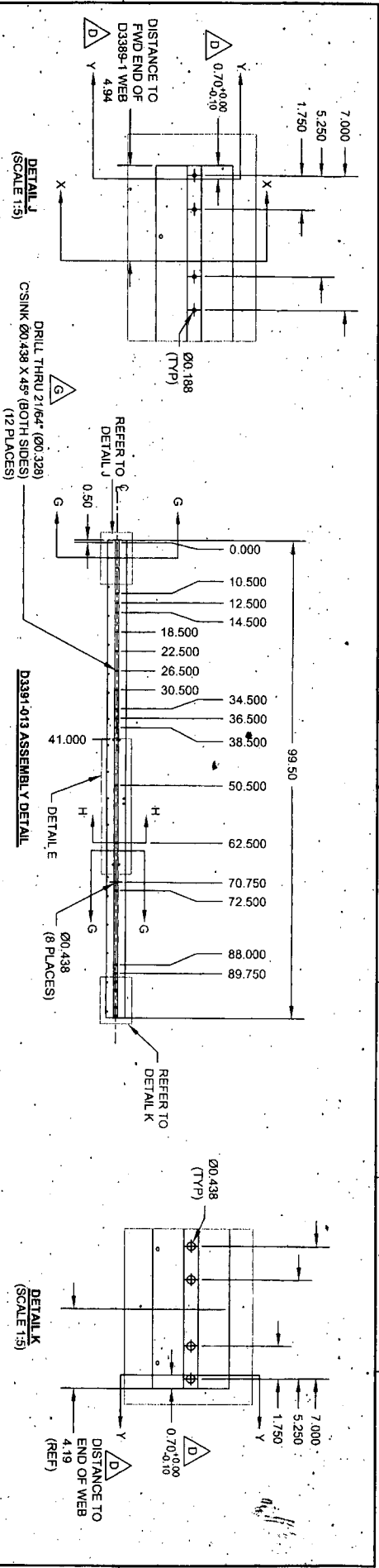
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION G-G
(SCALE 1:4)

SECTION H-H (12 PLACES)
(SCALE 1:4)

SECTION X-X
(SCALE 1:4)

SECTION Y-Y
(SCALE 1:4)

SECTION M-M
(SCALE 1:4)

SECTION L-L-L
(SCALE 1:4)

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-013	MID TUBE ASSEMBLY
1	D3500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C16L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D3500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX 241/291 PER OSI 015
 - 3) WELDING: PER DART OSI 004

SECTION L-L
(SCALE 1:4)

RELEASED
07-11-2014

DESIGN	DRW	DART AEROSPACE USA, INC
CHECKED	CHK	PORT HADLOCK, WA
MFG APPR	APP	REV. G
APPROVED	APP	D3391
DATE	07.07.31	TITLE
		412 FLOAT SKIDTUBE
		SHEET 3 OF 8
		SCALE 1:20

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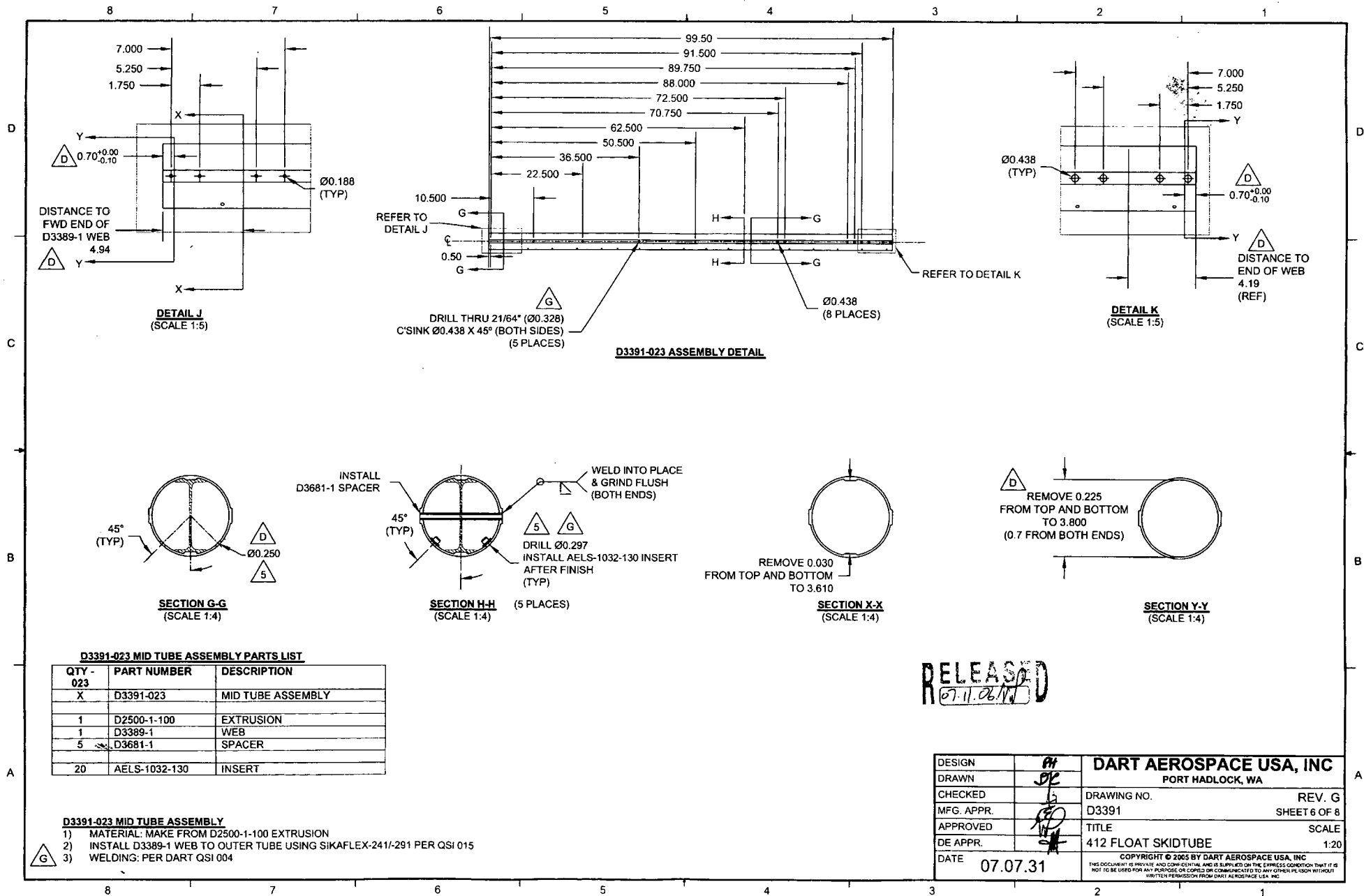
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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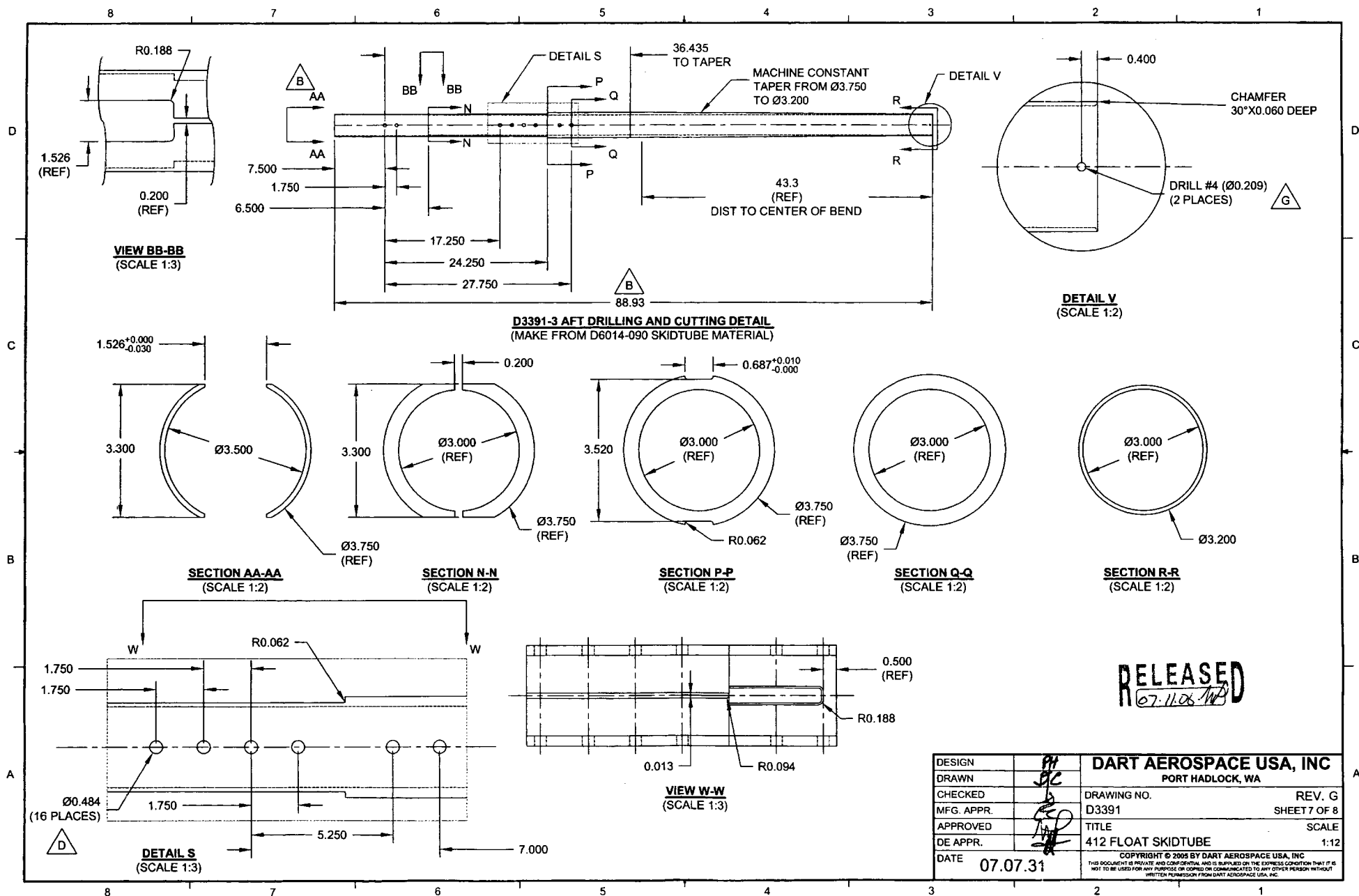
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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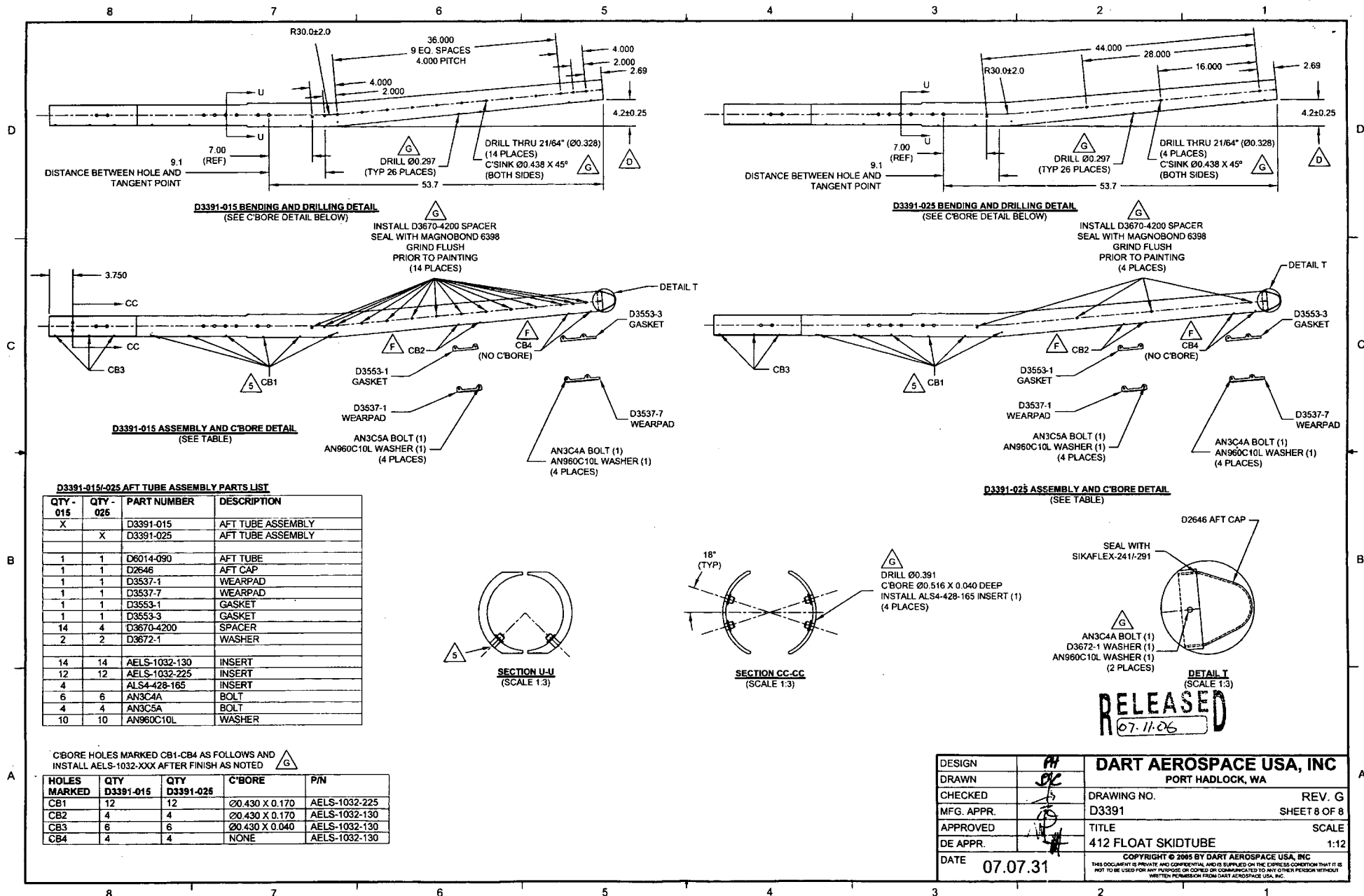
QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:12
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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NO. 145

AWS D17 1.2001
QUALIFICATION TEST RECORD

Name Berkeley E.
Joint Welding Procedure GTAU
Part number and Job number D339 102 / B 3576

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down	Up
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input checked="" type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-04-13 Qualifier Pat. Naval